Form: rorocess

	The same of the sa	*		Dart Aerosp	ace Ltd.
	nday, 2/19/2007 8:07:17 AM				
User: Kim	Johnston	Proce	ss Sheet		
Customer Job Number Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & Appro Comment Additional Product	: N A : 2/19/2007 S.O. No. :	/MED FAB	Part Number Drawing Number Project Number Drawing Revision Material Due Date	: PLATE : D323823 : D3238 REV B : N/A : B : N/A : 2/26/2007 Qty:	8 Um: Each
				e Nov	
Job Number:					
0 4	Machine Or Operation:		Description :		
Seq. # :	Machine Or Operation: M2024T3S080	2024-T3 .0			• .
1.0	NI2024133000	202 10 .			
	nent: Qty.: 0.0252 sf(s)/Unit Tota	al: 0.2016 sf(s)	l w	Λ :	4
704	M2024-T3 .080 Sheet Batch: 1848			17 07/02/1	11 9
2.0	WATER JET	FLOW WA	ATER JET		
					e en ante
Comm	nent: FLOW WATER JET				
	1-Cut as per Dwg D3238 Dwg Rev: 8 Prog Rev: 8 2-Deburr if necessary	12 107/02/1 0			
	*****USE D3238 BLANK CUTTIN	JG FII F****		``*\u_{i'}	
3.0	MILLING CONV.		FIONAL MILLING MACHIN		
			<u> </u>		
Comn	nent: CONVENTIONAL MILLING MAC				1/07.02.20
4.0	Machine Serration on Sheet usin		PARTS AS THEY COME	OFF MACHINE	1101.01.20
			TANTO NO THE TOUR		71
	nent: INSPECT PARTS AS THEY CO		TED IST		-/M/0702.2
.5.0	WATER JET	FLOW WA	MEK JET		
Comm	nent: FLOW WATER JET			(0)
	1-Cut as per Dwg D3238 Dwg Rev: <u>/3</u> ///	07 02 23	2_	Y	/
•	Dwg Rev: 13 // Prog Rev: 13 .	01000			

Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER (CHANGES			• •	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector
		·					
		ig the					
					:		
			<u> </u>				<u> </u>

Part No:	PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:	07/02/-
			QA: N/C C	losed:	Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Anneoval	Anneval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
								,

NOTE: Date & initial all entries

	day, 2/19/2007 8:07:18 AM Johnston	Process Sheet	Andrew Control of the
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: PLATE	<u> </u>
Job Number:	307//3	Part Number: D323823	
Job Number:		1 WISTIMITATION	
Seq. #:	Machine Or Operation:	Description :	
	2-Deburr if necessary	ml 07 02 22	(9)
	***Use cutting file D3238-21-23-25**		
6.0	QC2	INSPECT PARTS AS THEY COME OFF MA	CHINE
	m	070222	(9)
	ent: INSPECT PARTS AS THEY, COME		
7,0		SECOND CHECK	
			11111111111111111111111111111111111111
Comme 8.0	ent: SECOND CHECK HAND FINISHING1	HAND FINISHING RESOURCE #1	/ . /
0.0	HAND FINISHING I	TIMED HEROTHER TREES, ASE W.	
Comme	nt: HAND FINISHING RESOURCE #1	40	07/02/022 X9
	Chemical Conversion Coat as per Q	ISI 005 4.1 INSPECT POWDER COAT/CHEMICAL CON	
9.0	QC3	INSPECT FOWDER COATION LIMITOR CO.	
Comme	nt: INSPECT POWDER COAT/CHEMIC		12/22 (8)
10.0	PACKAGING 1	PACKAGING RESOURCE#1	
Comme	nt: PACKAGING RESOURCE #1 Identify and Stock	1	
	Location:	101/2/22	9,
11.0	QC21	FINAL INSPECTION/W/O RELEASE	
			(9)
Comme	nt: FINAL INSPECTION/W/O RELEASE	E _L	207/02/22
Job Completion			W 2022
			11 Klibber
	• •		\mathcal{N}^{V}
,			ı

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		· · · · · · · · · · · · · · · · · · ·					
L							
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

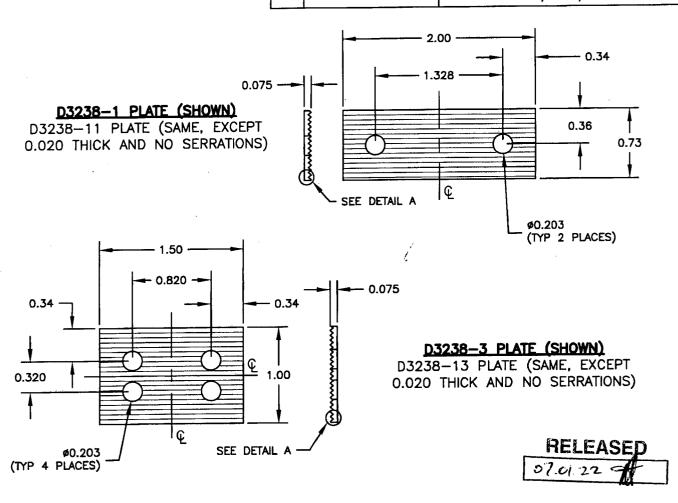
QA: N/C Closed: ____ Date: ___

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
-		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Varification	Ammrayal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Approval Section C Chief Eng		Approval QC Inspector
						ı	;	
						:		•
		,						

NOTE: Date & initial all entries



	DESIGI	4	DRAWN BY	DART AEROS HAWKESBURY, ONTA	
h	CHECK	ŒD	APPROVED /	DRAWING NO.	REV. B
				D3238	SHEET 1 OF 3
ŀ	DATE	<u> </u>	491	тть	SCALE
١	07.0	1.17		PLATE	1:1
	Α		03.11.25	NEW ISSUE	
	В		07.01.17	ADD -21/-23/-25/- CHANGE -11/-13/-1	-31/-33/-35; 5 TO 6061-T6



NOTES:

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020) RETURN TO

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1

ENGINEERING

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

UNCONTROLLED COPY

4) ALL DIMENSIONS ARE IN INCHES 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT

6) SEE SHEET 3 FOR DETAIL A

WITHOUT NOTICE

7) PARTS ARE SYMMETRIC ABOUT &

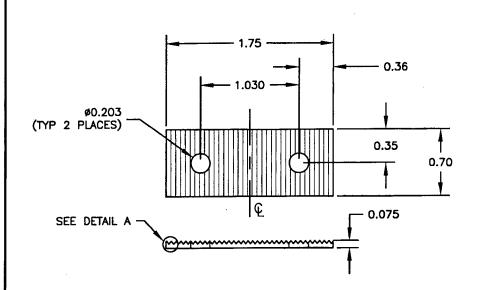
NO. 30743

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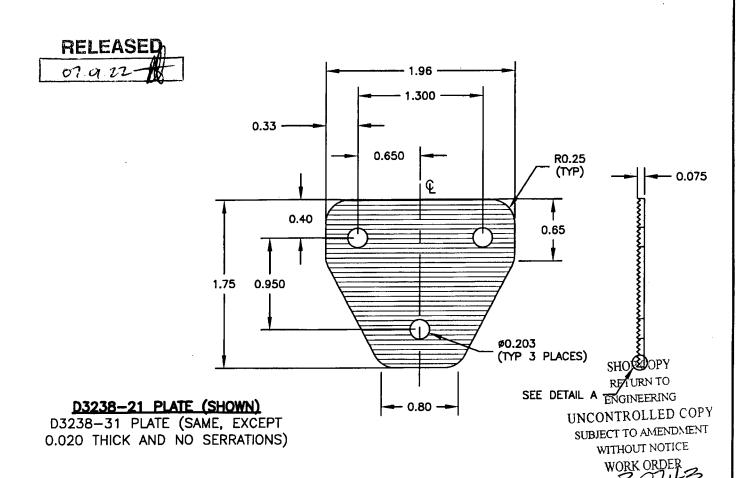
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DESIGN 4	CB		ROSPACE LTD y, ontario, canada
CHECKED	APPROVED A	DRAWING NO.	REV. B
16		D3238	SHEET 2 OF 3
DATE		TITLE	SCALE
07.01.17		PLATE	1:1



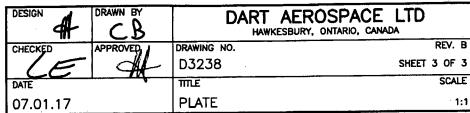
D3238-5 PLATE (SHOWN) D3238-15 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

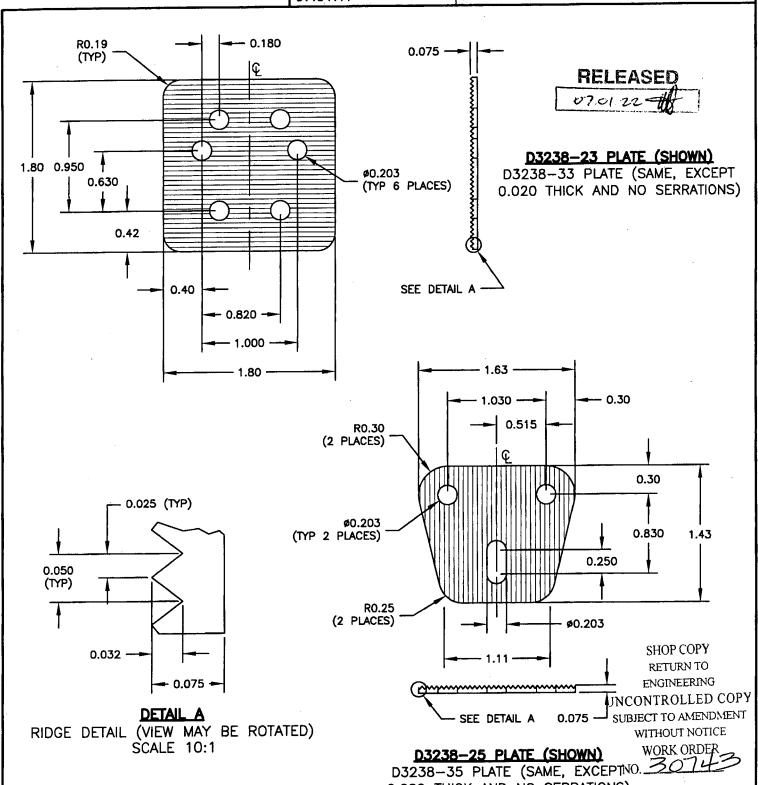


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0.020 THICK AND NO SERRATIONS)

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DART AEROSPACE LTD	Work Order:	30743
	Part Number:	D3238-23
Description: DIATE	Part Number.	
Inspection Dwg: \\\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		- T	Destations
X	First Article		Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	.ejest	Method of Inspection	Comments
\$ 0.203	+0.005-0.00]	0.203	1		vern	
1.80	41-0.030	1.803	1		VRUN	
1.80	+1-0.030	1.804	J		NELN	
0.950	+1-0.010	0.950	1		Vern	
0.40	41-0.030	0.395	4		VerN	
0.42	+1-0.030	0.413	1		VerN	
		7				
				-		
	•					
			 	-		
				1	J	

Measured by:		ml·ml 07 02 22	Audited by:	Prototype Approval:	
			Date:	Date:	
				Revised by	Approved
Rev	Date	Change		KJ/JLM	
Α		New Issue		110/0	